

Work Order ID 83963

Monday, April 30, 2012 10:59:57 AM

83963

Page 1

Item ID: D4277-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib *4*
Start Date: 5/1/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/8/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: *MF* Date: *12-04-30* Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4277	D								
100		0.00							
100									
Large Fab	Memo	0.00							<i>4</i> <i>SAJ</i> <i>12-05-16</i>
Large Fab	1- Cut tube as per dwg D4277 2- Remove marking,debur								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							<i>(4)</i> <i>SAJ</i> <i>12-05-16</i>
Quality Control									
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.00							<i>4</i> <i>SAJ</i> <i>12-05-16</i>
Packaging	***STOCK IN BASKET CELL***								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83963***83963***

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Item ID: D4277-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rib

Stop ***NS2***

Start Date: 5/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/5/17 *[Signature]*
ME
12-05-17

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Picklist Print

Monday, April 30, 2012 10:59:56 AM

Page 1

Work Order ID: 83963

Parent Item: D4277-7

Parent Item Name: Rib

Start Date: 5/1/2012

Required Date: 5/8/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
REV.C DD verf:EC

IPP Rev:B 11.01.20 AS PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	770.4922	0.1442	0.3035789		12-05-16	

Location

Loc Qty

Loc Code

MAT034

770.4922093

118460

0.00001534

121328

167.492194

121565

603

0.8070

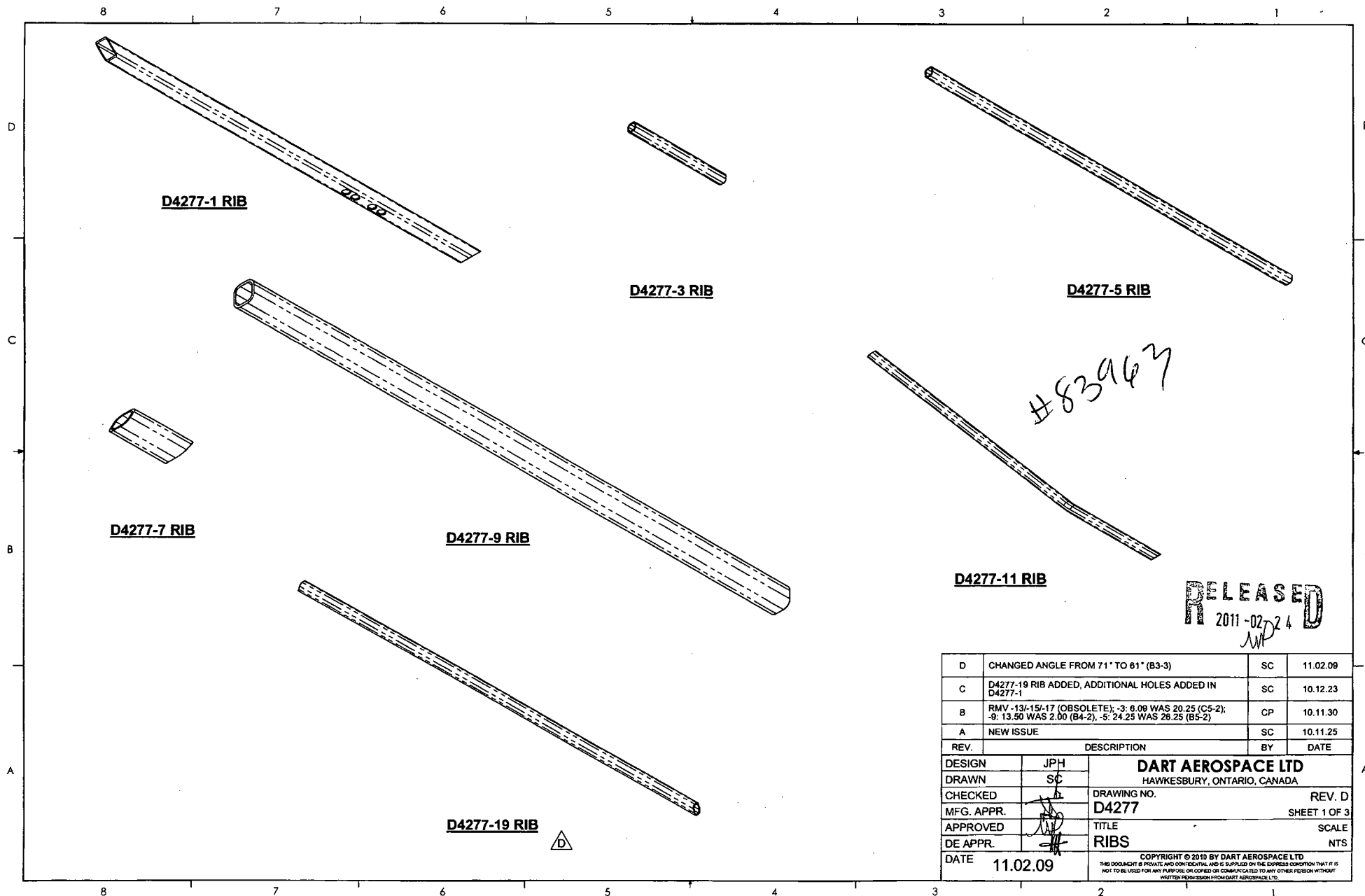
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D	CHANGED ANGLE FROM 71° TO 81° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/-15/-17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4277	SHEET 1 OF 3
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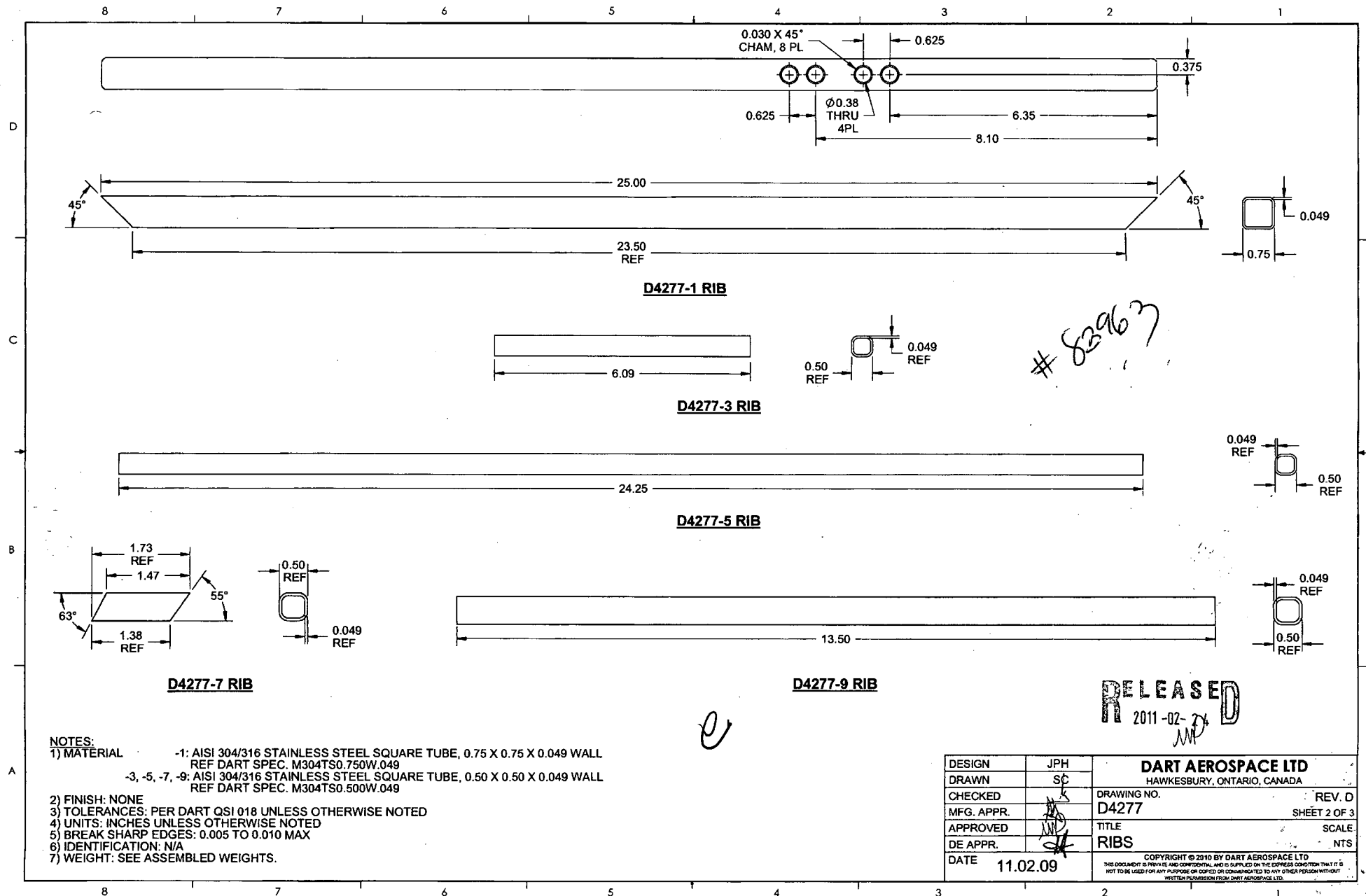
Dart Aerospace Ltd

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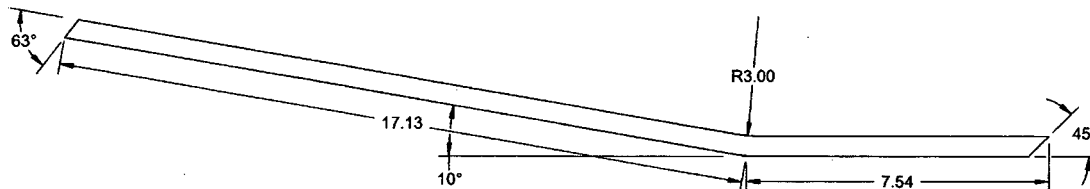
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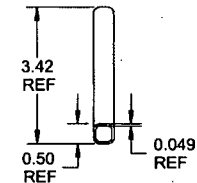
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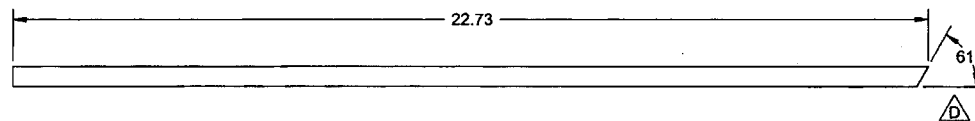
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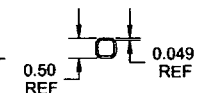
D4277-11 RIB



83963



D4277-19 RIB



RELEASED
2011-02-24

- NOTES:**
 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
 REF DART SPEC. M304TS0.500W.049
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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